Work Order ID 91472

October-10-12 2:46:51 PM

91472

Item ID: D4543-1 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Retainer, Outer, LH

Start Date: 10/10/2012 **Start Qty:** 15.00 *15*

Required Date: 11/02/2013 **Req'd Qty:** 15.00 *15*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** MLJ **Date:** 12-10-10 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D4543	A								
100		0.00							
100						15	0		JM 13-1-20
Waterjet	**Memo**	0.00							
FLOW CNC Waterjet	1- Cut as per dwg Prog rev: A Dwg rev: A								
	2- Deburr								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110						15	0		JM 13-1-20
QC	**Memo**	0.00							
Quality Control									

SCRAP

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Crosstube ☐
- Water Jet ☐
- Engineering ☐
- Machining ☐
- Small Fab ☐
- Prod. Eng. Coor. ☐
- Quality ☐
- Thermoforming ☐
- Finishing ☐
- Rec/Store/Packaging ☐
- Other ☐
- Large Fab ☐
- Composite ☐
- Supplier ☐
- ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped.
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Work Order ID 91472

October-10-12 2:46:51 PM

91472

Item ID: D4543-1 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Retainer, Outer, LH

Start Date: 10/10/2012 **Start Qty:** 15.00 *15*

Required Date: 11/02/2013 **Req'd Qty:** 15.00 *15*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** ____ **Date:** ____ **Tooling:** ____ **Date:** ____

QC: ____ **Date:** ____ **SPC (Y/N):** ____ **Date:** ____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00				15			
120									
QC	**Memo**	0.00							
Quality Control									
130		0.00							
130									
Small Fab	**Memo**	0.00							
Small Fab	FORM ON BEAD ROLLER (DT9787)					15	0		13-01-31
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	**Memo**	0.00							
Quality Control									

AS 15 S-89 13-1-22

FF

RTD

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: [illegible] Date: 13/02/07

QA Closed: [illegible] Date: [illegible]

Work Order: 91472

Part No. D 4543-1

NCR No. 13-2289

DISPOSITION

Rework	
Scrap	X
Use-as-is	
Work Order Update	

AGAINST DEPARTMENT/PROCESS

Skid-tube		Crosstube		Water Jet		Engineering	
Machining		Small Fab	X	Prod. Eng. Coor.		Quality	
Thermoforming		Finishing		Rec/Store/Packaging		Other	
Large Fab		Composite		Supplier			

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data		13/1/31	120	15	part scrap do not match qc Template over tolerance QTY (15) R.C. Parts were formed to much.	DAS 1F 9-89 QS2042 13/1/31	part Destroyed and redo with New B# NO replace 4 @ 21.88 X1.5 10940 10940 21880 32.82	13-01-31 FF	DAS 15 9-89 13-1-31	DAS 1F 9-89 QS2042 13/1/31
Equip/Tooling										
Operator	X									
Material										
Setup										
Other										
Process										
Supplier										
Training										
Unapproved										

FAULT CATEGORY

Landing Gear

	Bending
	Centre Not Concentric to O/S
	Cracks
	Crushed/Crimped
	Cuffs
	Heat Treat
	Inspection Strip in Tube
	Ripples in Bend
	Torque Waves in Extrusion
	Turning Sequence
	Wave/Twist in Tube

General

	Bend
	BOM/Route
	Broken/Damaged
	Burrs
	Contamination
	Countersink
	Cut Too Short
	Drill Holes
	Drawing
	Finish
	Folio

	Grain
	Hardware
	Inspection Incomplete
	Instructions Incomplete/Unclear
	Maintenance
	Mislabeled
	Misread
	Offset
	Out of Calibration
	Out of Sequence
	Outside Dimensions

	Ovalized
	Over/Under tolerance
	Part Incorrect
	Part Lost/Missing
	Part Moved
	Positioned Wrong
	Power Loss/Surge

	Pressure/Forced
	Temperature/Cure
	Weld
	Wrong Stock Pulled
	Other

x operator didn't check Dwg. After making 1st part

Work Order ID 91472

October-10-12 2:46:51 PM

91472

Item ID: D4543-1 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Retainer, Outer, LH

Start Date: 10/10/2012 **Start Qty:** 15.00 *15* **Cust Item ID:**

Required Date: 11/02/2013 **Req'd Qty:** 15.00 *15* **Customer:**

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Stop** *NR2*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150									
HandFinish	**Memo**	0.00							
Hand Finishing									
160	QC7-Inspect Chemical Conversion Coat	0.00							
160									
QC	**Memo**	0.00							
Quality Control									
170	Identify as per dwg & Stock Location:_____	0.00							
170									
Packaging	**Memo**	0.00							
Packaging									

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

Work Order ID 91472

October-10-12 2:46:51 PM

91472

Item ID: D4543-1 **Accept** *N9000040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Retainer, Outer, LH

Start Date: 10/10/2012 **Start Qty:** 15.00 *15* **Cust Item ID:**

Required Date: 11/02/2013 **Req'd Qty:** 15.00 *15* **Customer:**

Reference:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	**Memo**	0.00							
Quality Control									

11-3-21

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐
- ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Picklist Print

October-10-12 2:46:55 PM

Work Order ID: 91472 *91472*

Parent Item: D4543-1 *D4543-1*

Parent Item Name: Retainer, Outer, LH

Start Date: 10/10/2012 **Required Date:** 11/02/2013

Start Qty: 15.00 **Required Qty:** 15.00

Comments: IPP revA 12.01.04 New Issue EC verified by:DD IPP
REV:B 12.02.24 as per dwg reva DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased	No			100	sf	700.0600	0.611	~~9.647368~~			
M6061T6S.032									**	9.7			JM 13-T-20
6061-T6 Sheet 0.032"													

Location	Loc Qty	Loc Code	
MAT021	700.06		
121099	85.97		
122256	40.89		
122737	30.1		
123097	91.1		
123135	96		
123137	356		123137

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

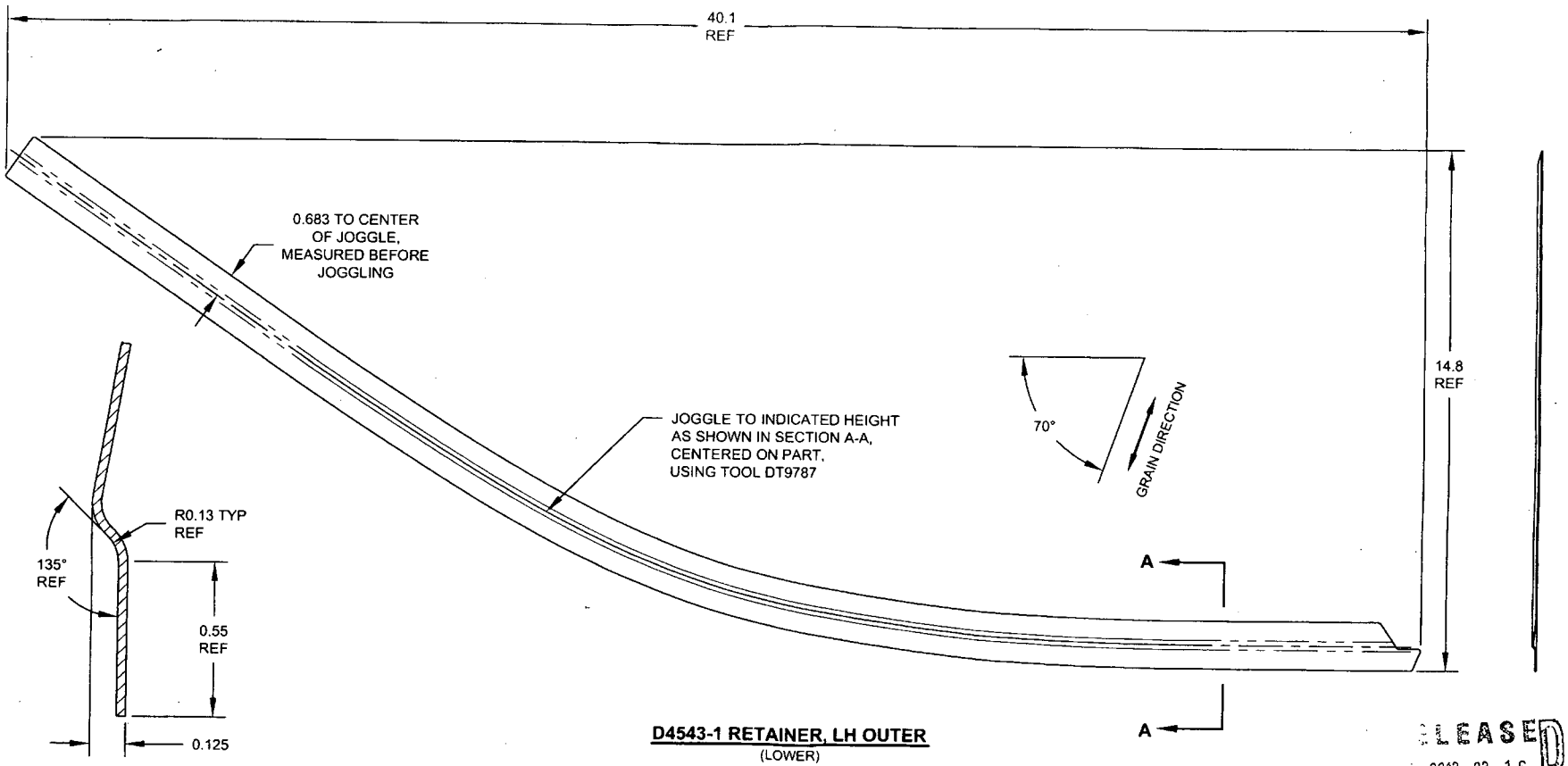
DART AEROSPACE LTD	Work Order:	91472
Description: Retainer, LH Outer	Part Number:	D4543-1
Inspection Dwg: D4543 **Rev:** A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.620	+/-0.010	0.620"	–			
0.65	+/-0.030	0.650"	–			
1.15	+/-0.030	1.15"	–			
1.365	+/-0.010	1.368"	–			
14.8	+/-0.030	14.8"	–			
40.1	+/-0.030	40.1"	–			
0.032	+/-0.010	0.032"	–			

Measured by:	JM	Audited by:	AS 15-69	Preliminary Approval:	
Date:	13-1-20	Date:	13-1-22	Date:	

Rev	Date	Change	Revised by	Approved
A	12.03.08	New Issue	KJ	



SECTION A-A
JOGGLE DETAIL
SCALE 8X

D4543-1 RETAINER, LH OUTER
(LOWER)

RELEASED
2012 -02- 16

SHOP
RETURN
ENGINEER
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 91472 MCS
12-10-10

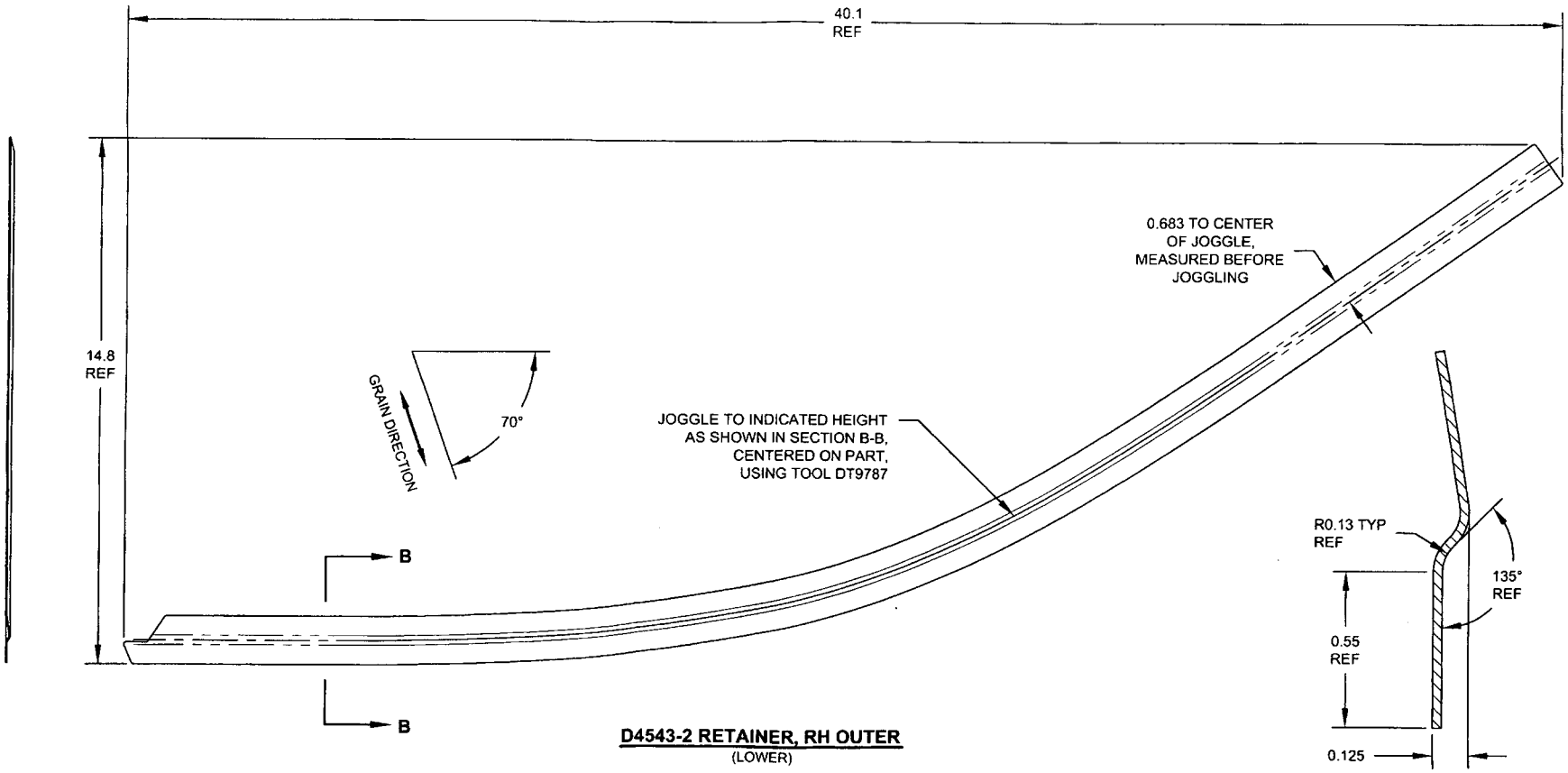
NOTES:
1) MATERIAL: MAKE FROM D4543-1F
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1
7) WEIGHT: 0.19 lbs

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	CP	12.01.09

DESIGN	QP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	QP	
CHECKED		DRAWING NO. D4543 — REV. A — SHEET 1 OF 6
MFG. APPR.		TITLE — SCALE
APPROVED		RETAINER, OUTER. — NTS
DE APPR.		
DATE	12.01.09	

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91472



D4543-2 RETAINER, RH OUTER
(LOWER)

SECTION B-B
JOGGLE DETAIL
SCALE 8X

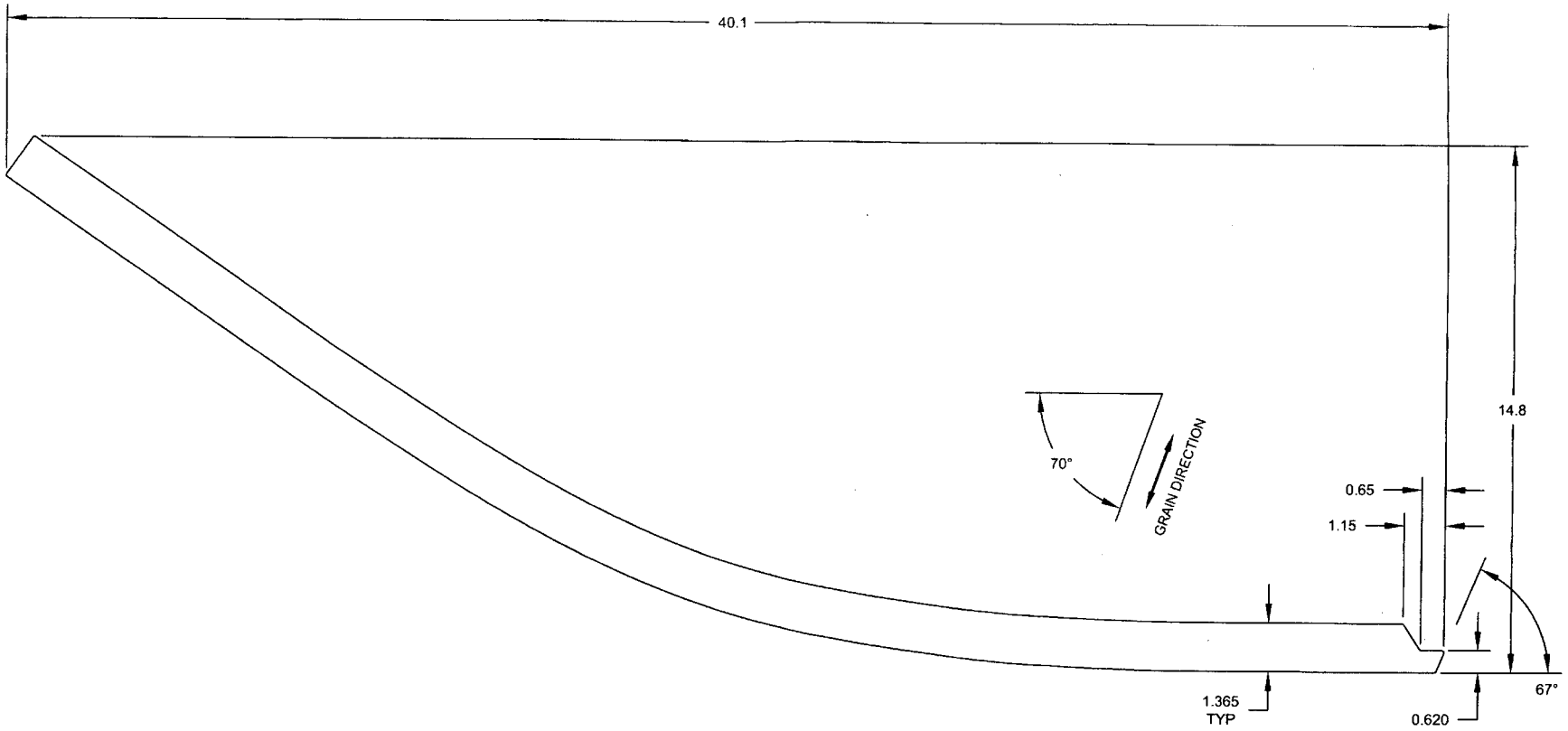
RELEASED
2012 -07- 16

NOTES:
1) MATERIAL: MAKE FROM D4543-1F
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1
7) WEIGHT: 0.19 lbs

DESIGN		**DART AEROSPACE LTD**	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4543	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		RETAINER, OUTER	NTS
DATE	12.01.09		

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91472



D4543-1F FLAT PATTERN

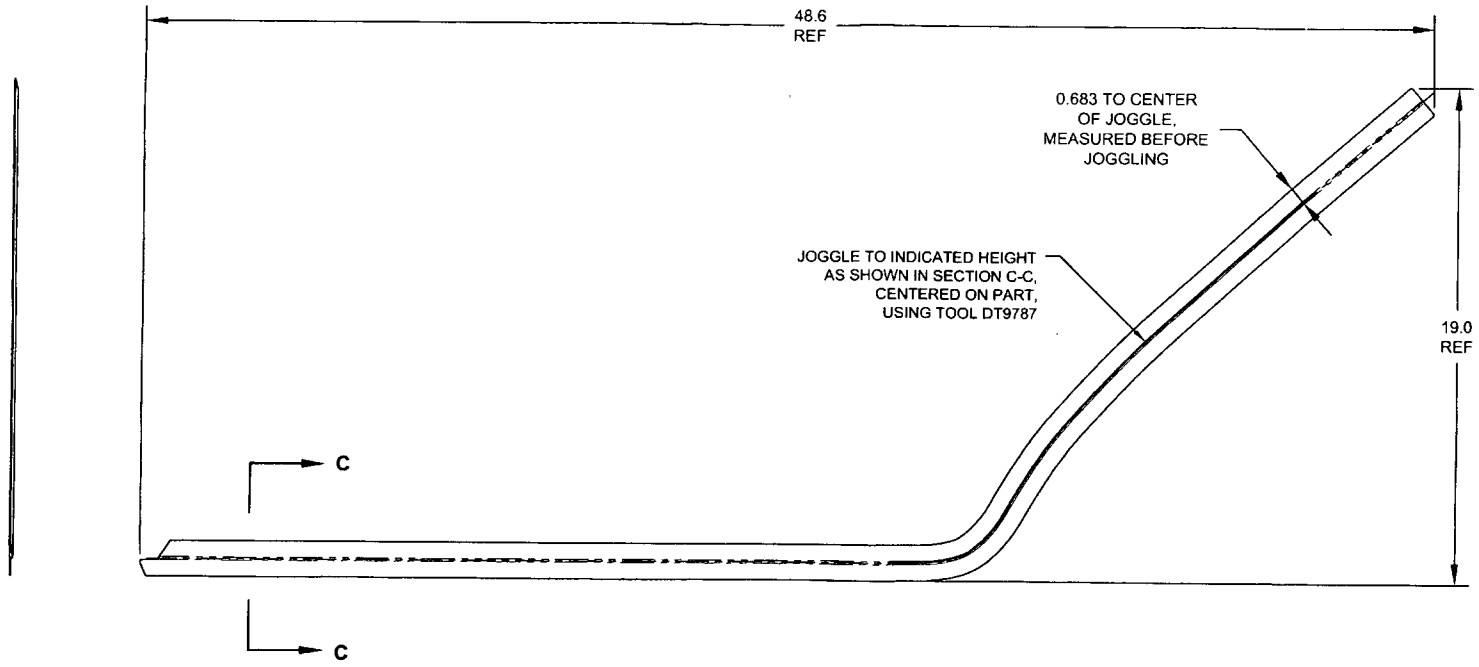
RELEASED
2012 -02- 16

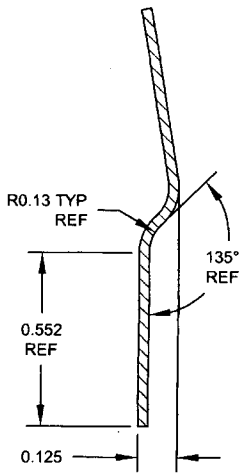
NOTES:
1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.19 lbs
8) PROFILE PER DRAWING FILE "D4543-1F-REVA.DXF"

DESIGN		**DART AEROSPACE LTD**	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4543	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		RETAINER, OUTER	NTS
DATE	12.01.09		

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91472





SECTION C-C
JOGGLE DETAIL
SCALE 12X

D4543-3 RETAINER, LH OUTER
(SIDE/TOP)

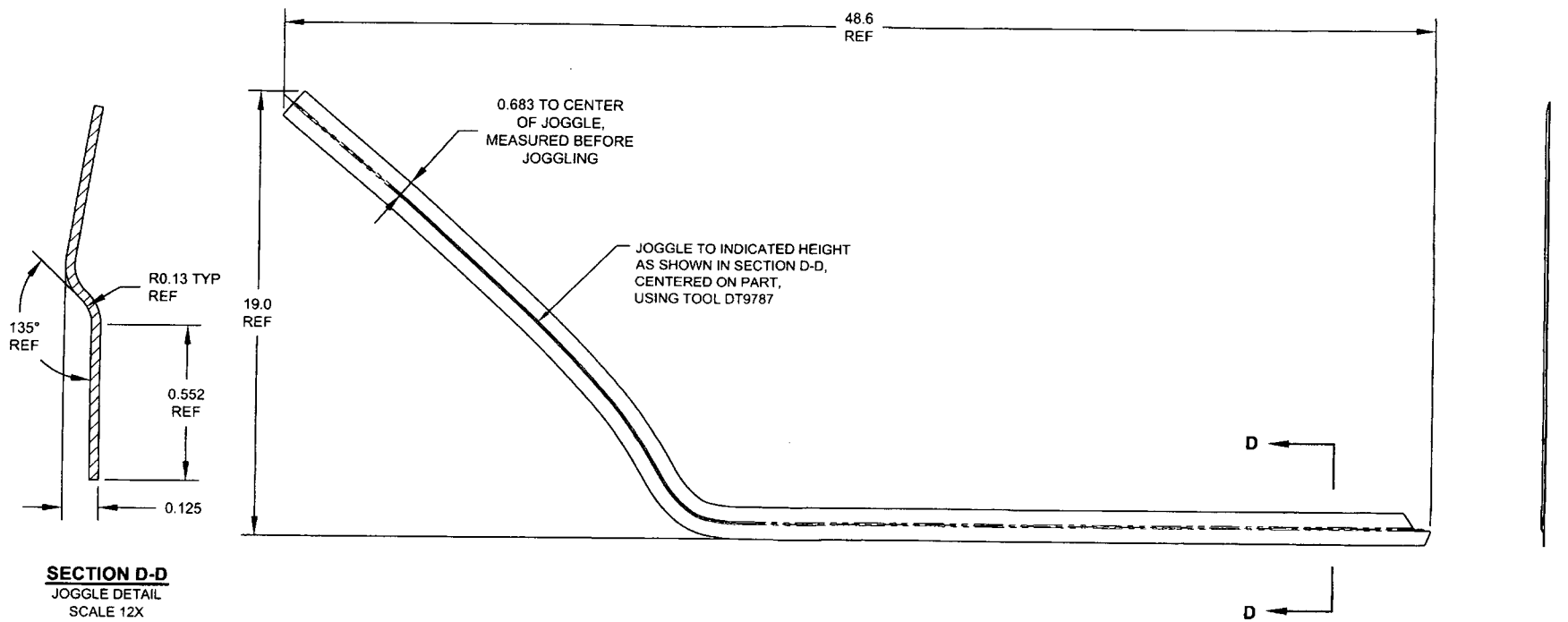
RELEASED
2012 -02- 16

NOTES:
1) MATERIAL: MAKE FROM D4543-3F
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1
7) WEIGHT: 0.24 lbs

DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D4543 — REV. A — SHEET 4 OF 6
MFG. APPR.		
APPROVED		TITLE: RETAINER, OUTER — SCALE: NTS
DE APPR.		
DATE	12.01.09	

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SECTION D-D
JOGGLE DETAIL
SCALE 12X

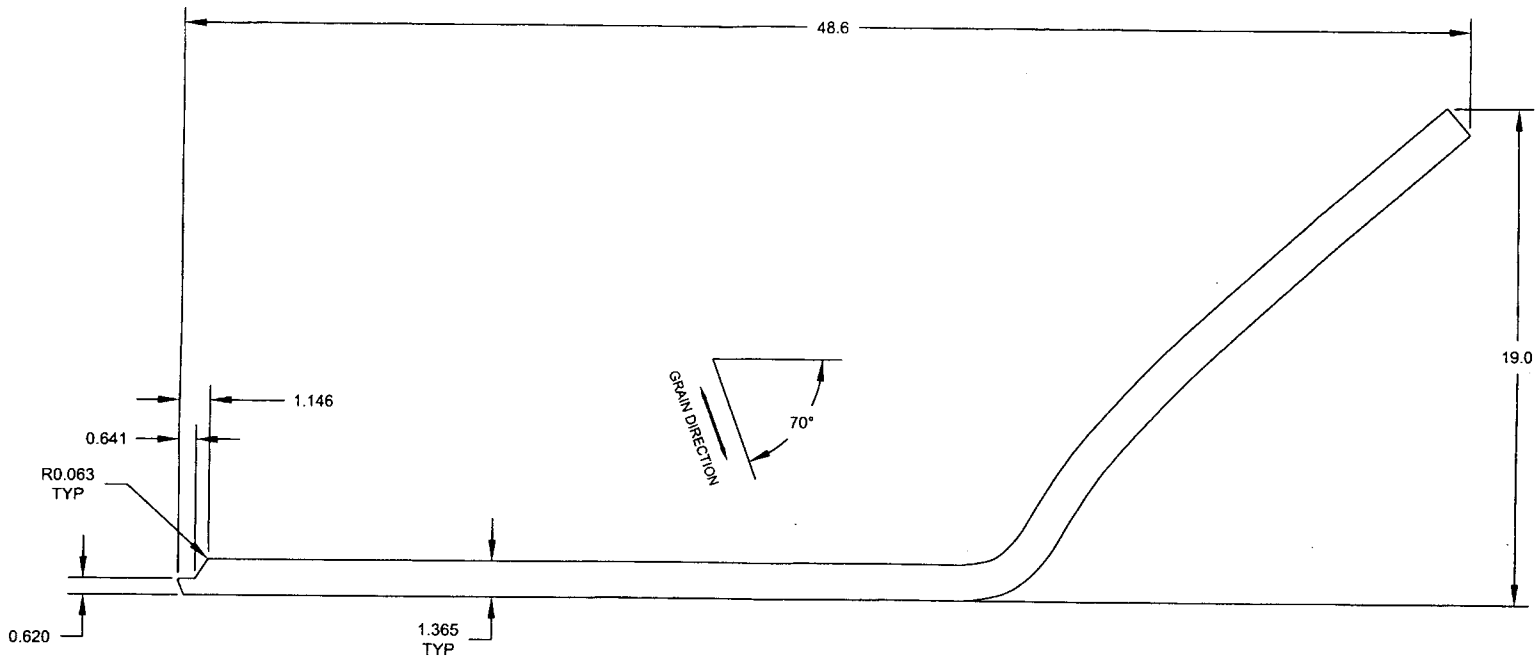
D4543-4 RETAINER, RH OUTER
(SIDE/TOP)

RELEASED
2012 -02- 16

NOTES:
1) MATERIAL: MAKE FROM D4543-3F
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1
7) WEIGHT: 0.24 lbs

DESIGN		**DART AEROSPACE LTD**	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4543	SHEET 5 OF 6
APPPOVED		TITLE	SCALE
DE APPR.		RETAINER, OUTER	NTS
DATE	12.01.09		

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D4543-3F FLAT PATTERN

RELEASED
2012 -02- 16

NOTES:
1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.24 lbs
8) PROFILE PER DRAWING FILE "D4543-3F-REVA.DXF"

DESIGN		**DART AEROSPACE LTD**	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4543	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		RETAINER, OUTER	NTS
DATE	12.01.09		

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